

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014154**Date Inspected:** 10-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**TOWER TRIAL ASSEMBLY**

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005702

**Visual Inspection Testing (VT)**

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Component. The identified component and weld designations reviewed are as follows:

**WEST TOWER SKIN 'E', 15M ANGLE BRACKET****WSD1 – SA225G/H – 25; 26****Magnetic Particle Testing (MT)**

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

**WEST TOWER SKIN 'E', 15M ANGLE BRACKET**

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WSD1 – SA225G/H –26

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005706

## Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Component. The identified component and weld designations reviewed are as follows:

### WEST TOWER LIFT 1, ELEVATOR SUPPORT

Z69 – O – A/F – 11 – 1 – W

Z69 – O – A/F – 11 – 2 – W

Z69 – O – A/F – 12 – 1 – W

Z69 – O – A/F – 12 – 2 – W

Z69 – O – A/F – 13 – 1 – W

Z69 – O – A/F – 13 – 2 – W

## Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

### WEST TOWER LIFT 1, ELEVATOR SUPPORT – GREEN TAG# 12686

Z69 – O – A/F – 11 – 1 – W

Z69 – O – A/F – 11 – 2 – W

This QA Inspector observed the following work in progress:

### Shielded Metal Arc Welding (SMAW):

Weld joint # 01 located on West Tower Lift – 1 Skin ‘A’ doubler plate P475 - W. Welder is identified as 202100. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – B – U2a – 1. (See attached photo)

Weld joint # 03 located on West Tower Lift – 1 Skin ‘A’ doubler plate P475 - W. Welder is identified as 040724. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4213 – Tc – U4c – 2.

## Tower

### MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY WEST TOWER LIFT-1

This QA Inspector carried out the measurements on WestTower Lift-1 Exterior side to check the distance from the edge of the base plate anchor bolt holes to the side of the bearing, type-1 & 2 stiffeners for skin ‘C’. Measurements were recorded on the data sheet and submitted to the assigned task leader.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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